



!!!! WARNING !!!!



WELDING FUMES AND GASES CAN BE DANGEROUS TO YOUR HEALTH.

BEFORE USING THIS PRODUCT THE WELDER (END-USER) MUST READ AND UNDERSTAND THE COMPLETE PRODUCT WARNING LABEL AND MATERIAL SAFETY DATA SHEET (MSDS).

THE MATERIAL SAFETY DATA SHEET (MSDS) WHICH OUTLINES THE POTENTIAL HEALTH HAZARDS AND SAFETY INFORMATION RELATED TO THIS PRODUCT CAN BE DOWNLOADED FROM THE MSDS PORTION OF THIS WEBSITE. IT IS ALSO AVAILABLE FROM YOUR EMPLOYER AND WELDING SUPPLY DISTRIBUTOR.

DO NOT PROCEED WITH USE OF THIS PRODUCT UNTIL YOU READ AND UNDERSTAND THE MATERIAL SAFETY DATA SHEET (MSDS) AND PRODUCT WARNING STATEMENT.

BE SURE TO CONSULT THE LATEST VERSION OF THE MSDS.

SEE THE PRODUCT WARNING LABEL AND MSDS FOR COMPLETE WARNING INFORMATION.



CROWN ALLOYS **COMPANY**

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Crown FH-30 Chrome-Moly MIG Wire

Typical Applications:

Repair and build up of dies, forgings and castings made from medium carbon low alloy steels. Joining 4130 steel when heat treatment or flame hardening is required.

Specifications: (Chromium-Molybdenum 4130)

- Hardness 32-36 (Rockwell C) as welded
 42-46 (Rockwell C) flame hardened
- Preheat 250°F to 450°F (for higher carbon grades)
- Hardening Heat to 1550°F to 1650°F.
 Quench in oil or water.
- Drawing 500°F

Procedure:

Prepare area to be welded by grinding out cracks and other defects. Remove all oxides and other contaminants. Preheat to recommended temperature and maintain during welding. Use reverse polarity (DCEP). Be sure to use a 98% Argon - 2% Oxygen shielding gas. Deposit short stringer beads. Peen thoroughly. Cool in still air.

Sizes:

	Amperage	Volts
.035 x 30#	140-190	26-29
.045 x 30#	180-200	28-30